

Date: Monday, 6/26/2006 11:17:20 AM
User: Brenda Leonard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 27685
Estimate Number : 11040
P.O. Number : N/A
This Issue : 6/26/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : 6/26/2006 Type : SMALL / MED FAB
Previous Run : 27303
Written By : SEE COMMENT BELOW
Checked & Approved By : [Signature]
Comment : Est. A00.11.06 New Issue EC
Est. B06.05.30 Blanks on wtjetEC

Drawing Name : STA 155 BRACKET
Part Number : D28042
Drawing Number : D2804 REV B
Project Number : N/A
Drawing Revision : B
Material : N/A
Due Date : 7/3/2006
Qty: 14 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X12000 6061-T6 Bar .50" x 12.0"



Comment: Qty.: 0.7875 f(s)/Unit Total: 7.8750 f(s)

6061-T6 Bar .50" x 12.0"

Material: 6061-T6 bar 12.00" x 0.50"

Batch: M101263

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Template DT8534

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

SAD 06/06/27

14

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio FA103

mk/J.F. 06/07/01

14

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk/J.F. 06/07/01

14

5.0

QC8

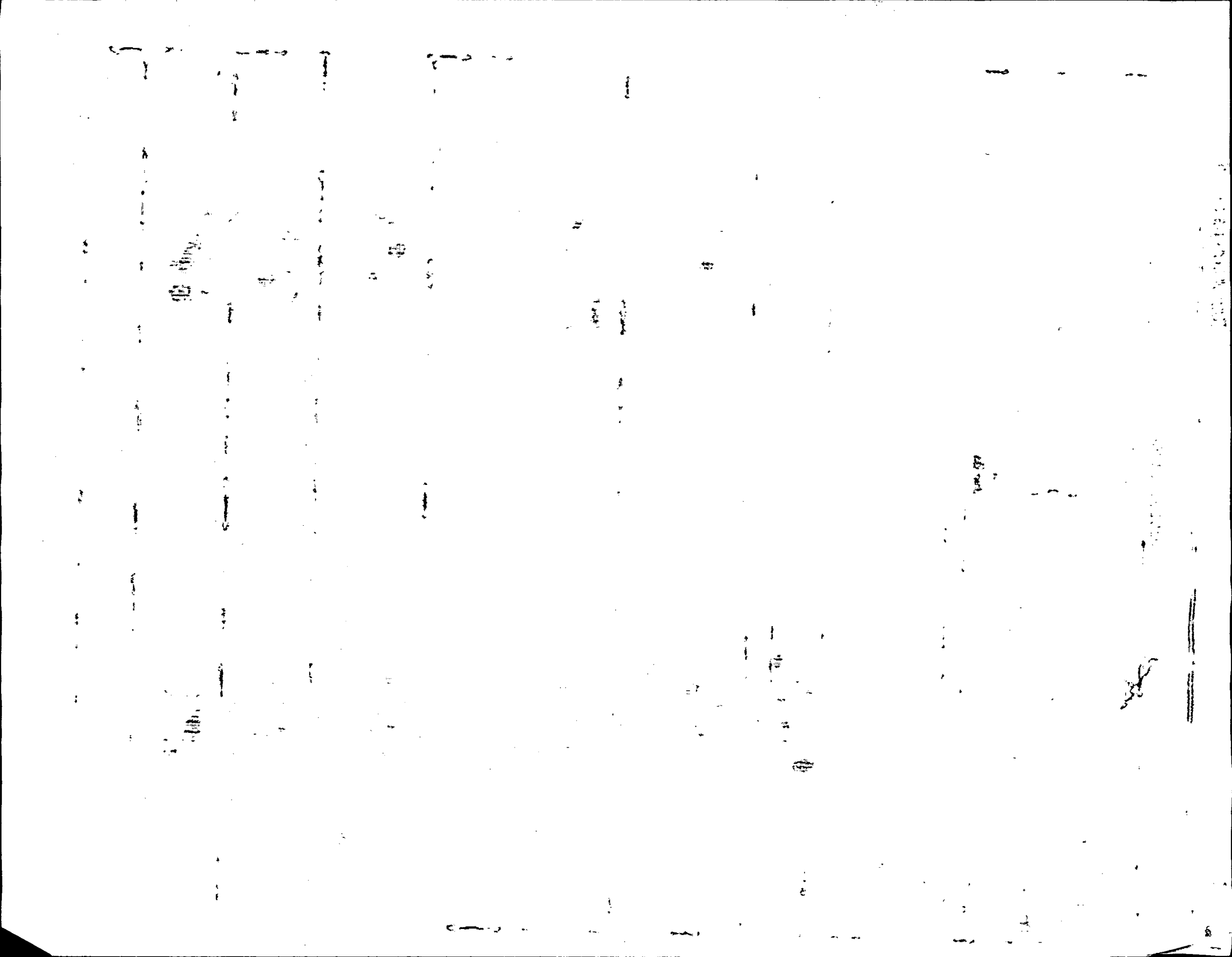
SECOND CHECK



Comment: SECOND CHECK

S.G. 06/07/02

14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: *06/11/06*

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/26/2006 11:17:20 AM
User: Brenda Leonard

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 27685

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

J.F.

06/07/01

14

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

J.G

06/07/02

14

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

SAD

06/07/04

14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: ST156

06/07/05

(14)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21



06/07/06

(14)

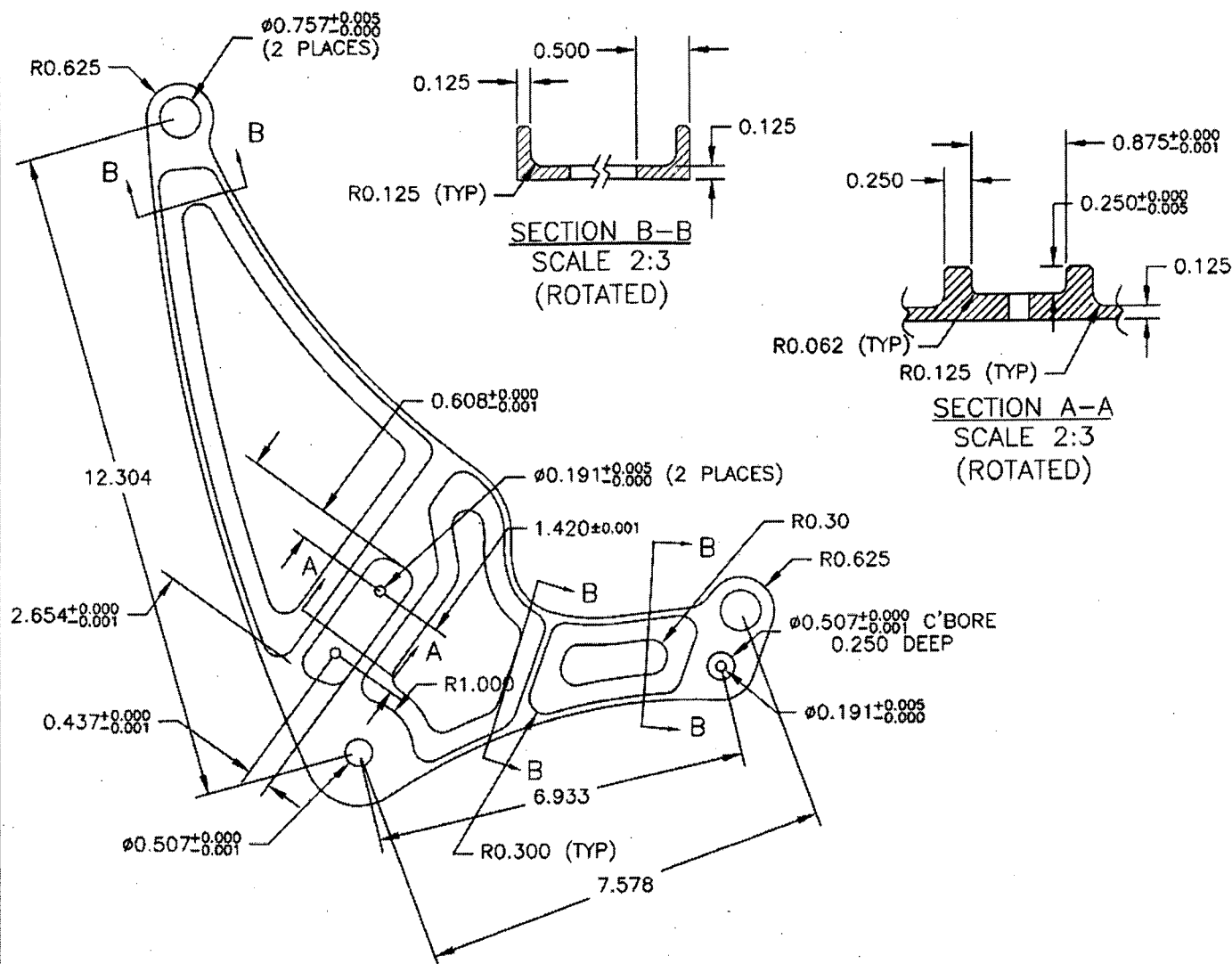
Job Completion



U 06/07/05

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

05-03-11



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

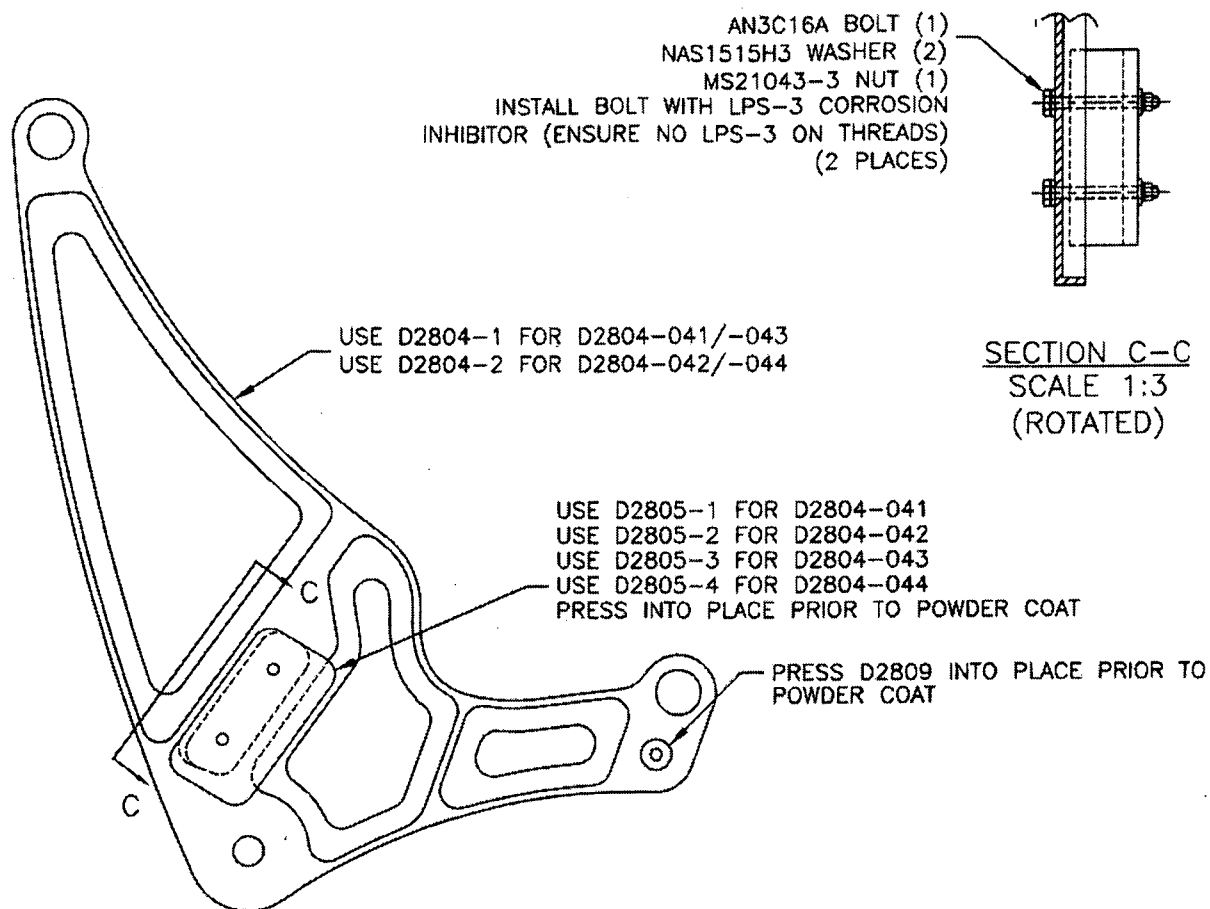
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3



RELEASED

05-03-11 [Signature]

D2804-041/-043 BRACKET ASS'Y (SHOWN)
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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DART AEROSPACE LTD		Work Order: 27685
Description: STA 155 BRACKET		Part Number: D2804-2
Inspection Dwg: D2804, Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.625	± 0.016	R0.624	—			
Ø0.757	± 0.005 ± 0.006	Ø0.759	—			
12.304	± 0.016	12.304	—			
0.437	± 0.000 ± 0.001	0.437	—			
Ø0.507	± 0.000 ± 0.001	Ø0.507	—			
6.933	± 0.010	6.933	—			
7.578	± 0.016	7.578	—			
Ø0.191	± 0.005 ± 0.000	Ø0.191	—			
Ø0.507	± 0.000 ± 0.001	Ø0.507	—			
0.250	± 0.016	0.249	—			
1.420	± 0.001	1.421	—			
0.608	± 0.000 ± 0.001	0.608	—			
0.125	± 0.010	0.124	—			
0.125	± 0.016	0.122	—			
0.500	± 0.010	0.498	—			
R0.125	± 0.016	R0.125	—			
0.250	± 0.010	0.250	—			
R0.062	± 0.016	R0.062	—			
0.875	± 0.000 ± 0.001	0.8746	—			
0.250	± 0.006 ± 0.005	0.250	—			

Measured by: <i>mf</i>	Audited by: <i>Er</i>	Prototype Approval: <i>NIA</i>
Date: 06/06/30	Date: 06/06/30	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

